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**ABSTRACT**

An apparatus for cutting sheet metal pieces from a sheet metal coil comprises a coil support adapted to support the sheet metal coil such that same may rotate about the coil axis to unroll an end portion of the sheet metal coil and a sheet support adapted to support the end portion for cutting. A cutting head is mounted above the end portion and is operative to cut through the end portion. A cutting head drive is operative to move the cutting head back and forth along a first path parallel to the coil axis and a sheet metal drive is operative to move the end portion forward and rearward along a second path perpendicular to the coil axis. A computer is operative to control and coordinate the sheet metal drive and the cutting head drive such that the pieces are cut from the end portion.